

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008239**Date Inspected:** 27-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Weing Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

BAY # 1

Magnetic Particle Inspection

This QA Inspector performed Magnetic particle Testing of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (MT) report for this date. The members are identified as the Floor Beam for CB 7 Designation are as follows.

FB205-016-027, 034, 001, 008, 020, 021, 024, 005, 006

BAY # 3

Visual Inspection

During random in-process visual inspection of Crossbeam CB10 Deck panel in Bay# 3, This Caltrans Quality Assurance (QA) Inspector observed the root opening of a weld joint CB202B010-003 is between 7 to 9mm. This root opening exceeds the tolerances specified in AWS D1.5 2002. An incident report was issued for this.

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This QA Inspector randomly observed the following work in progress

BAY#02

FCAW welding process of weld joint 148 located on PCMK FB024-009. Welder is identified as 207465 ZPMC QC is identified as Wang Liang. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F) Repair.

BAY#01

FCAW welding process of weld joint 003 located on PCMK CW001B-PP80. Welder is identified as 251246 ZPMC QC is identified as Zhang Yaxu. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4B-F.

FCAW welding process of weld joint 009 located on PCMK CW001B-PP54. Welder is identified as 219189 ZPMC QC is identified as Zhang Yaxu. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

This QA Inspector also noted that the following Counter Weight fit up in progress.

CW001B-PP066

CW001B-PP064

CW001B-PP058

BAY#03

FCAW welding process of weld joint 16 located on PCMK FB011-035. Welder is identified as 204338 ZPMC QC is identified as Shi Lei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

FCAW welding process of weld joint 045 located on PCMK FB009-033. Welder is identified as 044924 ZPMC QC is identified as Shi Lei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

FCAW welding process of weld joint 48 located on PCMK CA69. Welder is identified as 044830 ZPMC QC is identified as Yin Donghai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

FCAW welding process of weld joint 60 located on PCMK CA70. Welder is identified as 044830 ZPMC QC is identified as Yin Donghai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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remedial efforts please contact Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

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| Inspected By: | Utekar,Shrikant | Quality Assurance Inspector |
| Reviewed By: | Clifford,William | QA Reviewer |
